

Date: Tuesday, 6/27/2006 8:47:08 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT ASSEMBLY
Job Number	: 27416		
Estimate Number	: 11248		
P.O. Number	: N/A	Part Number	: D3438042
This Issue	: 6/27/2006 S.O. No. : N/A	Drawing Number	: D3438 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/5/2006 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	:	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/30/2006
Checked & Approved By	:	Qty:	8 Um: Each
Comment	: Est A 05.05.18 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D267334	End Plate
-----	---------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2673-34	End Cap	325394

L.E. 06.06.27

(P10)

2.0	D2561	Lug Plate
-----	-------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2561	Lug Plate	327417

(Scrapped 2) on the step.

L.E. 06.06.27

8

3.0	D2564	Mounting Angle
-----	-------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	325970 = 18

(Scrapped 2) on the step.

L.E. 06.06.27

8

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 79.63" at 34° as per Dwg D3438

2-Deburr ends

L.E. 06.06.27

8

L.E. 06.06.27

8

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 27416

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Inspect for foreign object per QSI 024

~~4-Weld last end cap H.E. 06.06.29 = 8~~

4-Weld as per Dwg D3438 using DT8343

~~5-Grind last end cap H.E. 06.06.29 = 8~~

5-Grind

RE 06.06.27 8

RE 06.06.28

FF 06.06.28 8

5.0

QC5/9

WELD INSPECTION



RE 06.06.28 8

Comment: WELD INSPECTION

QC9-AD 06.06.28 8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06.06.28 8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-07-13 8

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg 3438 and QSI 005 4.4

Mask off 0.5 each side of D2561 lugs

SL 06/07/13 8
DU

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PU 6/7/13 8

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
060704	6.1	QC 3 Inspect Alclad	J	06-06-30	8	W	0607.04	
	6.2	Weld last end cap 2673-34. Check for foreign objects ^{As per QSI 004} grind flush	J	06-06-30	8			
	6.3	QC 519 Inspect work: weld: for foreign objects. PD	J	0607-04	8			
060904	6.4	Alclad end CAP AS per necessary per per QSI 005 4.1	FF	06.06-28	8	J		
	4	make changes As shown. J	J	060704	8			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 11:01:38 AM
User: Kim Johnston









27394

Process Sheet


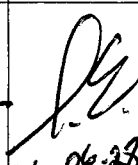
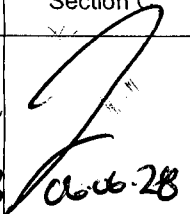
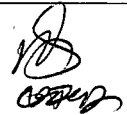

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT ASSEMBLY
Job Number	: 27416		
Estimate Number	: 11248		
P.O. Number	:	Part Number	: D3438042
This Issue	: 6/5/2006	Drawing Number	: D3438 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: //	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 6/30/2006
Checked & Approved By	:	Qty:	8 Um: Each
Comment	: Est A05.06.18 New Issue KJ/JLM		



Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D267334	End Plate
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part No. Description Batch 2 D2673-34 End Cap _____		
2.0	D2561	Lug Plate
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part No. Description Batch 2 D2561 Lug Plate _____		
3.0	D2564	Mounting Angle
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part No. Description Batch 2 D2564 Mounting Angle _____		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2244 to 79.63" at 34° as per Dwg D3438 2-Deburr ends 3-Inspect for foreign object per QSI 024		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27416		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.06.27	4	1 stop welded opposite to Dwg. Human Error.		Scrap, destroy, replace <u>AS PER DWG</u>	 06.06.28	 06.06.28		 06.06.27

Part No: D3438-042 PAR #: N/A Fault Category: Prod-Lg FAB NCR: ☒ Yes ☐ No DQA:  Date: 06.07.19
 NOTE: Date & initial all entries QA: N/C Closed:  Date: 06.07.19

Date: Monday, 6/5/2006 11:01:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT ASSEMBLY

Job Number: 27416

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Weld as per Dwg D3438 using DT8343.

5-Grind

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg 3438 and QSI 005 4.4
Mask off 0.5 each side of D2561 lugs

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

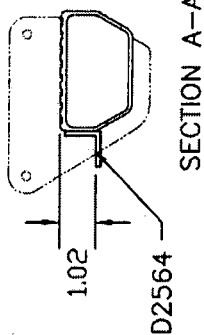
QA: N/C Closed: _____ Date: _____

DART

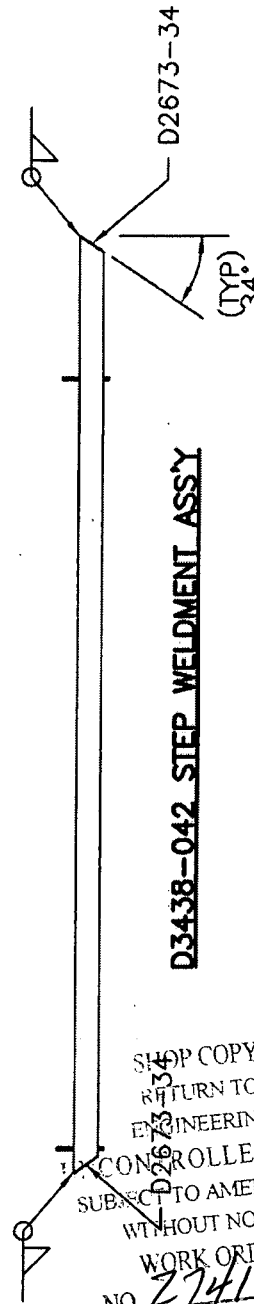
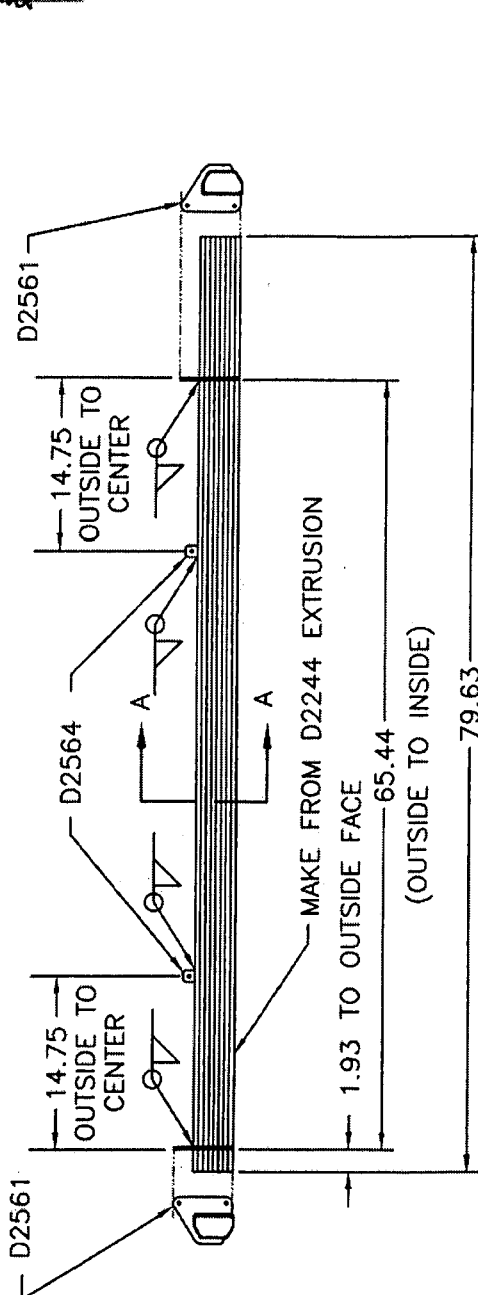
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3438	REV. A SHEET 1 OF 1
DATE 05.05.09	TITLE STEP WELDMENT ASSEMBLY		SCALE 1:1
A	05.05.09	NEW ISSUE	

RELEASED

05.05.27



SECTION A-A

**D3438-042 STEP WELDMENT ASSY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1 WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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